



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4093-1

Job Sheet 185832



Part No: D4093-1

Job Qty: 10 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/4/18

Job Tracking No:

Due Date: 11/19/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEETS 1,2 Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD IPP REV:B AS PER REV C
11.09.28 JLM VERIFIED BY:DD IPP REV:C 12.10.31 AS PER DWG REV.C DD VERF:JLM *use SIG-DT0100

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	10 pcs		11/19/18	0.00	2.94	Waterjet-Flow	OMAX	11/18/18
120	QC	10 pcs		11/19/18	0.00	0.00	QC2 Waterjet-3		11/18/18
130	Mill Conv	10 pcs		11/19/18	0.00	6.06	Mill Conv 1		11/18/18
135	QC	10 pcs		11/19/18	0.00	0.00	QC8		11/18/18
140	HandFinish	10 pcs		11/19/18	0.00	0.54	HandFinish1		11/18/18
160	QC	10 pcs		11/19/18	0.00	0.00	QC7-3		11/18/18
170	Packaging	10 pcs		11/19/18	0.00	0.00	Packaging3-2	51449	11/18/18
180	QC21-SA	10 Ea		11/19/18	0.00	0.00	QC21		11/18/18

Job BOM

Part / Item	Component Name	Quantity	Operation
M6061T6B0.750X06.000	6061T6 Bar .750 X 6.00	5.8000 ft (.58 ea)	110-Waterjet - Flow - 1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M6061T6B0.750X06.000	6	9	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.920Inches ± 0.030	0.950 0.890		
2	Bracket	3.850Inches ± 0.030	3.880 3.820		
3	Bracket	4.030Inches ± 0.030	4.060 4.000		
4	Bracket	5.030Inches ± 0.030	5.060 5.000		
5	Bracket	0.360Inches ± 0.030	0.390 0.330		
6	Bracket	0.760Inches ± 0.030	0.790 0.730		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

7	Bracket	4.820Inches ± 0.030	4.850 4.790	
8	Bracket	0.380Inches ± 0.030	0.410 0.350	
9	Bracket	4.200Inches ± 0.030	4.230 4.170	
10	Bracket	7.030Inches ± 0.030	7.060 7.000	
11	Bracket	0.750Inches ± 0.010	0.760 0.740	
12	Bracket	0.080Inches + 0.010 - 0.001	0.090 0.079	Diameter
13	Bracket	0.201Inches + 0.005 - 0.001	0.206 0.200	Diameter
14	Bracket	0.500Inches ± 0.030	0.530 0.470	
15	Bracket	1.500Inches ± 0.010	1.510 1.490	
16	Bracket	2.530Inches ± 0.010	2.540 2.520	
17	Bracket	1.500Inches ± 0.010	1.510 1.490	
18	Bracket	0.201Inches + 0.005 - 0.001	0.206 0.200	Diameter
19	Bracket	0.370Inches ± 0.010	0.380 0.360	Diameter
20	Bracket	100.000Degrees ± 0.500	100.500 99.500	Angle
21	Bracket	2.390Inches ± 0.030	2.420 2.360	
22	Bracket	1.580Inches ± 0.030	1.610 1.550	
23	Bracket	0.130Inches ± 0.030	0.160 0.100	
24	Bracket	1.130Inches ± 0.030	1.160 1.100	
25	Bracket	0.130Inches ± 0.030	0.160 0.100	

Plex 11/5/18 9:01 AM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S126124

Part: D4093-1

Job No: 185832

Serial No/Batch: S126124

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/08/18

1270 Aberdeen Street
Cambridge, ON K4A 1K7
TEL: 1 519 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					